Work Order ID	70686
Monday, June 13, 2011	1:32:06 PM



Page 1

Item ID:

D3537-1

Accept

Setup Start

Stop

Revision ID:

Start Date:

Item Name:

Required Date: 6/17/2011

Wearpad

6/13/2011

Start Qty: 50.00

Req'd Qty: 50.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: //-///-/3

Date:

Tooling:

SPC (Y/N):

Date: Date:

Run Start

B11-6-15

Stop

Sequence ID/ **Work Center ID**

Operation Description Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Reject Accept Qty. Qty

Reject Number

Insp. Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

Waterjet

FLOW CNC Waterjet

304,063

FLOW WATER JET

1-Cut as per Dwg D3537□Dwg Rev: ☐ □Prog Rev: ☐ □2-Deburr if necessary

0.00

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

1B11-6-15

Quality Control

120

Quality Control

QC8- Inspect parts - second check

Memo

& Noulis

W/O:	•		ORK ORDER CHANG	GES						
DATE	STEP	PRO	OCEDURE CH		Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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							·			
							<u> </u>			
Part No	:	PAR #:	Fault Cat	tegory:	NCR: Y	es N	o DQ	A:	_ Date: _	
	Re	esolution:	Disposit	ion:	QA: N/	Clos	ed:		Date: _	
NCR:			WORK OR	DER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC Section A	Section A Initial Action I			ription Sign & S			ification Approval Chief Eng	
			Chief Eng	Chief Eng		ate				

Work Order ID 70686 Monday, June 13, 2011 1:32:06 PM

Page 2

Item ID:

D3537-1

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name: Wearpad

Required Date: 6/17/2011

6/13/2011

Start Qty: 50.00

Req'd Qty: 50.00



Date:_____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool ID

Date:

Code

Tool # Plan

Stop

Reject

Qty

Start

Run

Number Stamp

Insp.

Sequence ID/

Work Center ID

130

Brake NC Brake NC

NC BRAKE

Operation

Description

0.00

0.00

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. □2-Identify as D3537-1

Qty

Accept

Reject

140

Large Fab

Large Fab

Large Fab

Memo

Memo

0.00

0.00

Qty Description Batch A/R 2059B Hardcoat
1 Volume 1 Volume 1 Volume 1 Volume 2 Volum

2059B Hardcoat

weld that penetrated through Wearpadif necessary

150

Quality Control

QC10- Inspect visual per QSI004- ground welds

11-06-29 JBL

Dart	Aeros	pace	Ltd
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	oopaec							
W/O:			WC	RK ORDER CHANG	GES	· · · · · · · · · · · · · · · · · · ·		
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date (Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	Re	solution:	Dispositio	າ:	QA: N/C CI	osed:	Date: _	<u> </u>
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCF	R)		
DATE	STEP	Description of NC				Verificat	ion Approval	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	C Chief Eng	QC Inspector
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Work Order ID 70686

Monday, June 13, 2011 1:32:06 PM



Page 3

Item ID:

D3537-1

Revision ID:

Item Name: Wearpad

Start Date:

6/13/2011

Start Qty: 50.00

Accept



Setup Start



Stop

Required Date: 6/17/2011

Req'd Qty: 50.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: _____ Date: ____

QC: Date:

Memo

Tooling:

Set Up/

Run Hours

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Sequence ID/

Work Center ID

160

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

courte

170

Powdercoat

180

Quality Control

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

START TIME: □FINISH TIME:

QC3- Inspect Part Finish

0.00

Memo

Memo

0.00

		14.6							
1		WC	RK ORDER CHAN	GES					
STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Re	esolution:	Dispositio	າ:	QA:	N/C Clo	sed:		Date: _	
	,	WORK ORDI	ER NON-CONFORM	IANCE	(NCR)			
STEP	Description of NC	Corrective Action Section B					ation		Approval
	Section A	Chief Eng	Action Description Chief Eng	1	Date	Section C	on C	Chief Eng.	QC Inspector
				-					
							· ·		
							,		}
		Resolution: STEP Description of NC Section A	STEP PROCEDURE CHAIR PAR #: Fault Category Resolution: Disposition WORK ORDI STEP Description of NC Section A Initial Chief Eng	STEP PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORM STEP Description of NC Section A Corrective Action Section A Chief Eng Chief Eng Chief Eng	STEP PROCEDURE CHANGE PAR #: Fault Category: NCF Resolution: Disposition: QA: WORK ORDER NON-CONFORMANCE STEP Description of NC Section A Corrective Action Section B Action Description Chief Eng Chief Eng	STEP PROCEDURE CHANGE By PROCEDURE CHANGE By PAR #: Fault Category: NCR: Yes I Resolution: Disposition: QA: N/C Clo WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Corrective Action Section B Initial Chief Eng Chief	STEP PROCEDURE CHANGE By Date PAR #: Fault Category: NCR: Yes No DQA Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty PAR #: Fault Category: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr Approval Chief Eng Date: Corrective Action Section B Chief Eng Chief Eng Sign & Date Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Corrective Action Description Sign & Date Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Corrective Action Description Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng Chief Eng

Work Order ID 70686

Monday, June 13, 2011 1:32:06 PM



Page 4

Item ID:

D3537-1

Accept

Setup Start

Revision ID:

Item Name:

Wearpad

6/13/2011 Start Date:

Start Qty: 50.00 Req'd Qty: 50.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start

Stop



Required Date: 6/17/2011

Date: _____

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

Packaging

Operation Description

Identify as per dwg & Stock Location

Set Up/ Run Hours

0.00

Tool ID

Tool # Plan Code

Accept Oty

Reject Oty

Run

Reject Number Stamp

Insp.

Packaging

200

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

	- Opmou								
W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	311								
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes 1	No DQA:	Date: _		
	R		-	sposition: Date: Date:					
NCR:		V	VORK ORD	ER NON-CONFORMAI	NCE (NCR)				
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval Chief Eng	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector	
i									
L	<u> </u>								

Picklist Print

Monday, June 13, 2011 1:32:12 PM

Work Order ID: 70686

D3537-1 Parent Item:

Parent Item Name: Wearpad



Start Date: 6/13/2011

Required Date: 6/17/2011

Page 1

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	119.1000	0.106	5.578947	9,		
304/316 Sheet .063				- Location		<u>Loc (</u>	<u>Qty</u>	Loc Code		1201		60	

119.1 MAT020 117275 4.3 117653 114.8



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W/O:			V	VORK ORDER CHANG	GES						
DATE	STEP	PRC	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No.		DAD #.	Foult Co.	A	NOD				D-4	<u> </u>	
Part No					NCR: Yes No DQA: Date: QA: N/C Closed: Date:						
NCR:				DER NON-CONFORM			·		Date		
					ction B		1				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Verific Section	on C	Approval Chief Eng	Approval QC Inspector	
_											
<u> </u>											
NATE D											

DART AEROSPACE LTD	Work Order:	10486
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype
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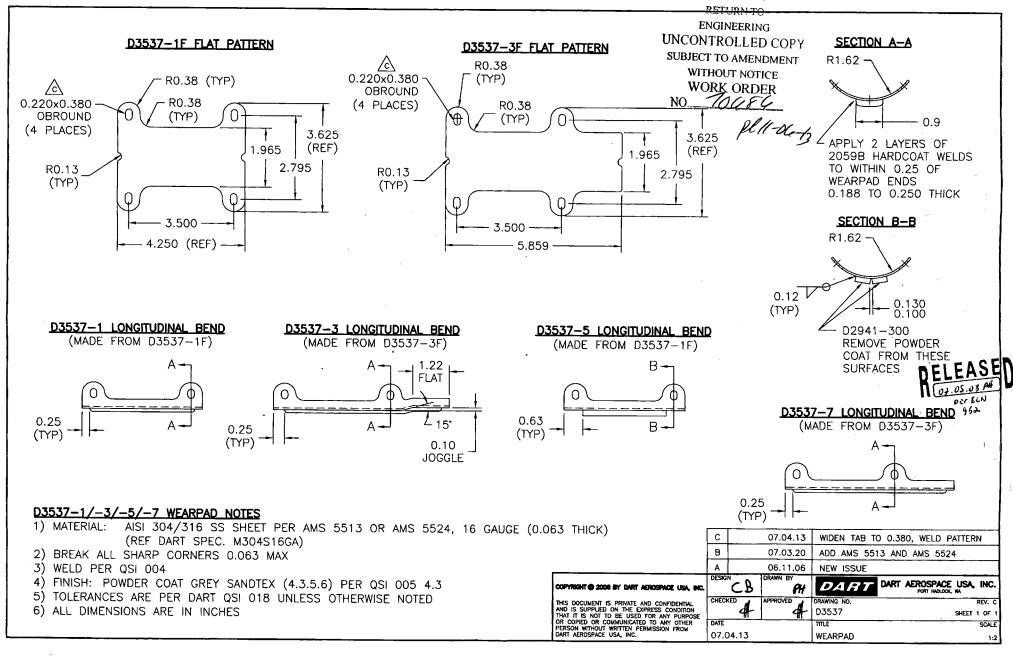
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4248	ю		U BOZ	
3.500	+/-0.010	3802	V		V	
1.965	+/-0.010	1.969	8		V	
2.795	+/-0.010	2,792	0		V	
3.625	+/-0.010	3676	×		V	
0.220 x 0.380	+/-0.010	990×380	8		$\sqrt{}$	

Measured by:	B	Audited by:		Prototype Approval:	N/A
Date:	11-6-15	Date: LU	06115	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
В	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	1
С	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM 🔣	

STEP			RK ORDER CHANGES					
	PR:	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
neso							Date	
STEP	Description of NC	Corrective Action Section B			Varificat			Approval
	Section A	Initial Chief Eng	Action Description Chief Eng		& Section		Chief Eng	Approval QC Inspector
	Reso	Resolution: Description of NC	Resolution: Disposition WORK ORDE STEP Description of NC Section A Initial	Resolution: Disposition: O WORK ORDER NON-CONFORMANC STEP Description of NC Section A Corrective Action Section B Initial Action Description	Resolution: Disposition: QA: N/C C WORK ORDER NON-CONFORMANCE (NC STEP Description of NC Section A Initial Action Description Sign	Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Corrective Action Section B Verification	Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Corrective Action Section B Verification Section C Section C	STEP Description of NC Corrective Action Section B Verification Approval Section A Approval Chief Eng

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W/O:			W	ORK ORDER CHANG	BES				
DATE STEP		PRO	CEDURE CHA	NGE	Ву	By Date Qty		Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:		V	VORK ORD	ER NON-CONFORM	ANCE (NC	R)		·	٠
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